

Work Order ID 77866

December-22-11 10:05:41 AM

77866

Page 1

Item ID: D206-651-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B GHW
 Start Date: 22/12/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 11/12/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D2711/D2690	Rev A/B2	<i>SP</i>

100 DOCUMENT CONTROL 0.00
100
 DC Memo 0.00
 Document Control Photocopy bluefile & type labels per PPP D206-651-041 CHG001

PICK KIT SP 12-01-24

ML 12-1-25
(49)

110 Small Fab 0.00
110
 Small Fab Memo 0.00
 Small Fab 1-Cut two cable CBL-1240 per assembly (10.75" each) Remove 2.25" of sleeve from each end of cable CBL-12402-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)3-Install Lanyard D2690-8 (from open end) into pin D2711 a

SP 12/01/26
(50)

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00
 Quality Control

SP 12/01/26

count
(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-651-041 CHG001 Location: _____ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

50x. SP 12-01-28

FG 122.

12/11/30 DJ

12-01-27
50

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Picklist Print

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Work Order ID: 77866

77866

Parent Item: D206-651-041

D206-651-041

Parent Item Name: 206A/B GHW

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: F 02.08.14 Re-format KJ
IPP Rev: G Removed Purchasing 07-03-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No				Each	0.0000		200			
AN960.ID10									**	200x			
Washer													
CBL-1240		Purchased	No				f	971.7965		94			
CBL -1240									**				
Cable													
<div> <div>Location</div> <div>GA</div> <div>113565</div> <div>118207</div> <div>119021</div> <div>119690</div> </div> <div> <div>Loc Qty</div> <div>971.7965259</div> <div>3.911789</div> <div>178.634737</div> <div>489.25</div> <div>300</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div>94</div> <div></div> <div></div> </div>													
CBL-460		Purchased	No				Each	931.0000		200			
CBL -460									**				
Loop Sleeve													
<div> <div>Location</div> <div>GA</div> <div>117947</div> <div>118140</div> <div>119021</div> <div>119690</div> </div> <div> <div>Loc Qty</div> <div>931</div> <div>4</div> <div>33</div> <div>188</div> <div>706</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div>200</div> </div>													
D2692		Manufactured	No				Each	340.0000		50			
D2692									**				
Spring Pin Clip													
<div> <div>Location</div> <div>ST020</div> <div>74121</div> </div> <div> <div>Loc Qty</div> <div>340</div> <div>340</div> </div> <div> <div>Loc Code</div> <div></div> <div>50x</div> </div>													

SP 12/20/12
EP 12/1/25

EP 12/01/25

SP 12-01-24

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Picklist Print

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77866

Parent Item: D206-651-041

D206-651-041

Parent Item Name: 206A/B GHW

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 50.00

Required Qty: 50.00

D2711

Manufactured No

Each

155.0000

50

D2711

**

Lock Pin

Location

Loc Qty

Loc Code

ST020

155

75062

155

MS21042L3

Purchased

No

Each

6,840.000

100

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

6840

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

796

MS27039-1-08

Purchased

No

Each

1,251.000

100

MS27039-1-08

**

Screw

Location

Loc Qty

Loc Code

ST291

1251

117423

77

118910

226

119075

448

119109

500

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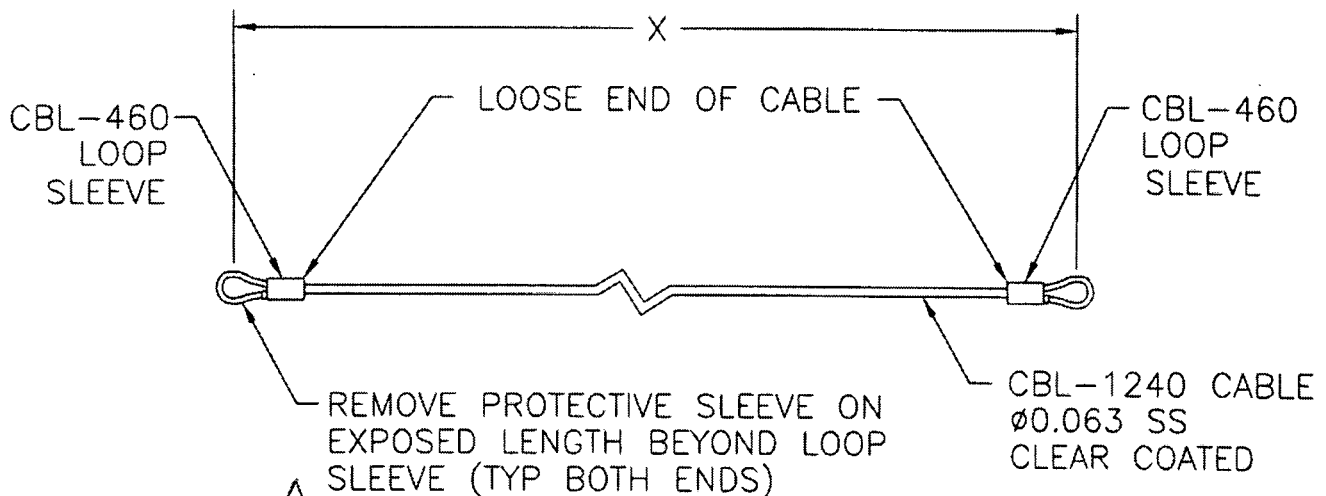
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DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	CP 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR 4374



~~B1 REMOVE 2.25" OF SLEEVE EACH END~~

B2 REMOVE 2.12" MIN - 2.25" MAX OF SLEEVE EACH END

D2690-X

X = LENGTH IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *77-866*
MZ-J

11/12/22

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH.
FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH
SLEEVE AT END OF LOOSE END OF CABLE WITH
CBL-705 CRIMPING TOOL.

*ADDITIONAL LENGTH MAY BE NECESSARY IN
SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER
ASSEMBLY WITH ATTACHING PARTS.

DEO's

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